

### **ABSTRACT OF THE DISCLOSURE**

A method of forming a nonwoven fabric suitable for metal-finishing  
buffing operations includes providing a precursor web comprising polyester,  
staple length fibers, with hydroentanglement of the web effected to impart  
5 desired physical characteristics. Hydroentanglement is effected on a three-  
dimensional, image transfer device having an array of three-dimensional surface  
elements for patterning the fabric which is formed. Application of a binder  
composition lends desired durability to the fabric, with the binder composition  
preferably including a melamine polymeric composition to achieve the desired  
10 strength and abrasion resistance.